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D3914-041
Job Sheet 183331



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/16/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Large Fab-5		CC
100	Large Fab	1 pcs	11/2/18	11/2/18	0.00	6.67	Large Fab 1		CC
110	QC	1 pcs	11/2/18	11/2/18	0.00	0.00	QC9		CC
120	QC	1 pcs	11/2/18	11/2/18	0.00	0.00	QC5		CC
130	Powdercoat	1 pcs	11/2/18	11/2/18	0.00	0.40	Powdercoat4		DEF 18-10-30
135	QC	1 pcs	11/2/18	11/2/18	0.00	0.00	QC3		18-11-01
140	HandFinish	1 pcs	11/2/18	11/2/18	0.00	0.80	HandFinish3		18-11-01
150	QC	1 pcs	11/2/18	11/2/18	0.00	0.00	QC3		18-11-01
160	Packaging	1 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-2		NOV 0 1 2018
170	QC21-SA	1 Ea	11/2/18	11/2/18	0.00	0.00	QC21		NOV 0 1 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M138839 START: 10:30 TEMP: 320° FINISH: 11:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5105222
D3914-1	Rib	2 Ea (2 ea)	90-Start up Operation	5116508
D3914-7	Rib	2 Ea (2 ea)	90-Start up Operation	5113730
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	5110937
D4018-5	Rib	9 Ea (9 ea)	90-Start up Operation	5110523
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	5113739
D4021-3	Data Plate	1 Ea (1 ea)	90-Start up Operation	5114284
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea)	90-Start up Operation	5114841

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

90-Start up Operation

D2581	2	92	0
D3914-1	2	11	0
D3914-7	2	16	0
D4016-3	3	22	0
D4018-5	9	57	0
D4020-5	1	2	0
D4021-3	1	14	0
D4035-043	2	14	0

Part Specifications

Specifications could not be found.

Plex 9/17/18 7:42 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	AGAINST Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐
Date :	Step #:	QTY Effective :
Description Work Order Deviation		Disposition
		QA Coordinator Approval

Root Cause				FAULT CATEGORY			
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
☐ Past Expiry Date	☐ Manufacturing Process	OTHER :					
☐ Misidentified	☐ Past Due						

Part: D3914-041
 Job No: 183331
 Serial No/Batch: S118276
 Revision: A/D
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 10/15/18



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QA Coordinator
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